

Work Order ID 73107

Thursday, August 25, 2011 4:03:37 PM



Page 1

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 8/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: *CL*

Date: *11/08/26*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3278	Rev C

100		0.00
	Small Fab	
Small Fab	Memo	0.00
Small Fab	Rivet spacers with support as per Dwg D3278.	

EP 11/10/12 (40)

110		0.00
	QC5- Inspect part completeness to step on W/O	
QC	Memo	0.00
Quality Control		

SB 11/10/12

(40)

120		0.00
	Small Fab	
Small Fab	Memo	0.00
Small Fab	Assemble support as per Dwg D3278.***DO NOT TIGHTEN BOLTS***Identify as D3278-041	

EP 11/10/12 (40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA:** N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 8/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				counts (40)			
140 Packaging Packaging	Identify as per dwg & Stock Location: 48 Memo	0.00 0.00							Rec'd 11/17 (40)
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/10/17 me 11-10-17

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 4:03:34 PM

Page 1

Work Order ID: 73107

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 8/26/2011

Required Date: 10/14/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 Support		Manufactured	No			100	Each	5.0000	1	40		8/11/10/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
					68956			5					
D3278-2 Support		Manufactured	No			100	Each	0.0000	1	40		8/11/10/11	
D3278-3 Spacer		Manufactured	No			100	Each	100.0000	1	40		8/11/10/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				100					
					68340			34					
					70984			66					
MS21042L4 Nut		Purchased	No			100	Each	4,143.000	2	80		8/11/10/12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST300				4143					
					117441			57					
					117601			637					
					117885			1449					
					118451			2000					

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Thursday, August 25, 2011 4:03:34 PM

Work Order ID: 73107

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 8/26/2011

Required Date: 10/14/2011

Start Qty: 40.00

Required Qty: 40.00

AN4-13A Purchased No

120 Each 846.0000 2 80



Bolt



8/24/10/12
M118706
(80x)

Location

Loc Qty

Loc Code

ST357

846

118078

594

118351

252

~~AN960JD416~~ NAS1149D0463J Purchased No

120 Each 0.0000 4 160



Washer

D2230-1



Lug

Manufactured No

120 Each 225.0000 2 80



8/24/10/12
8/24/10/12

Location

Loc Qty

Loc Code

ST476

225

67826

6

69179

19

69821

100

70974

100

MS20426AD3-6 Purchased No

120 Each 3,525.000 4 160



Rivet



8/24/10/12
160

Location

Loc Qty

Loc Code

ST316

3525

105055

115

116289

3410

Thursday, August 25, 2011 4:03:34 PM

Shop Packet Print

Page 2

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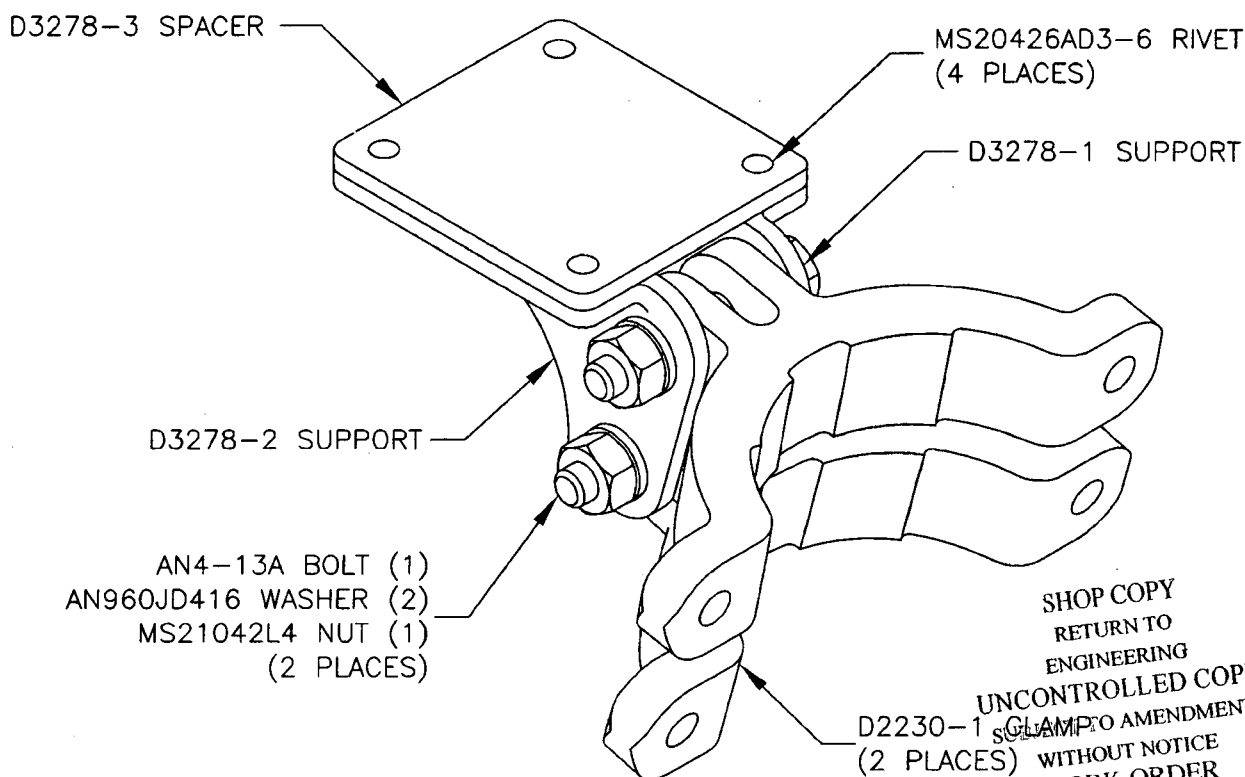
NOTE: Date & initial all entries



DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

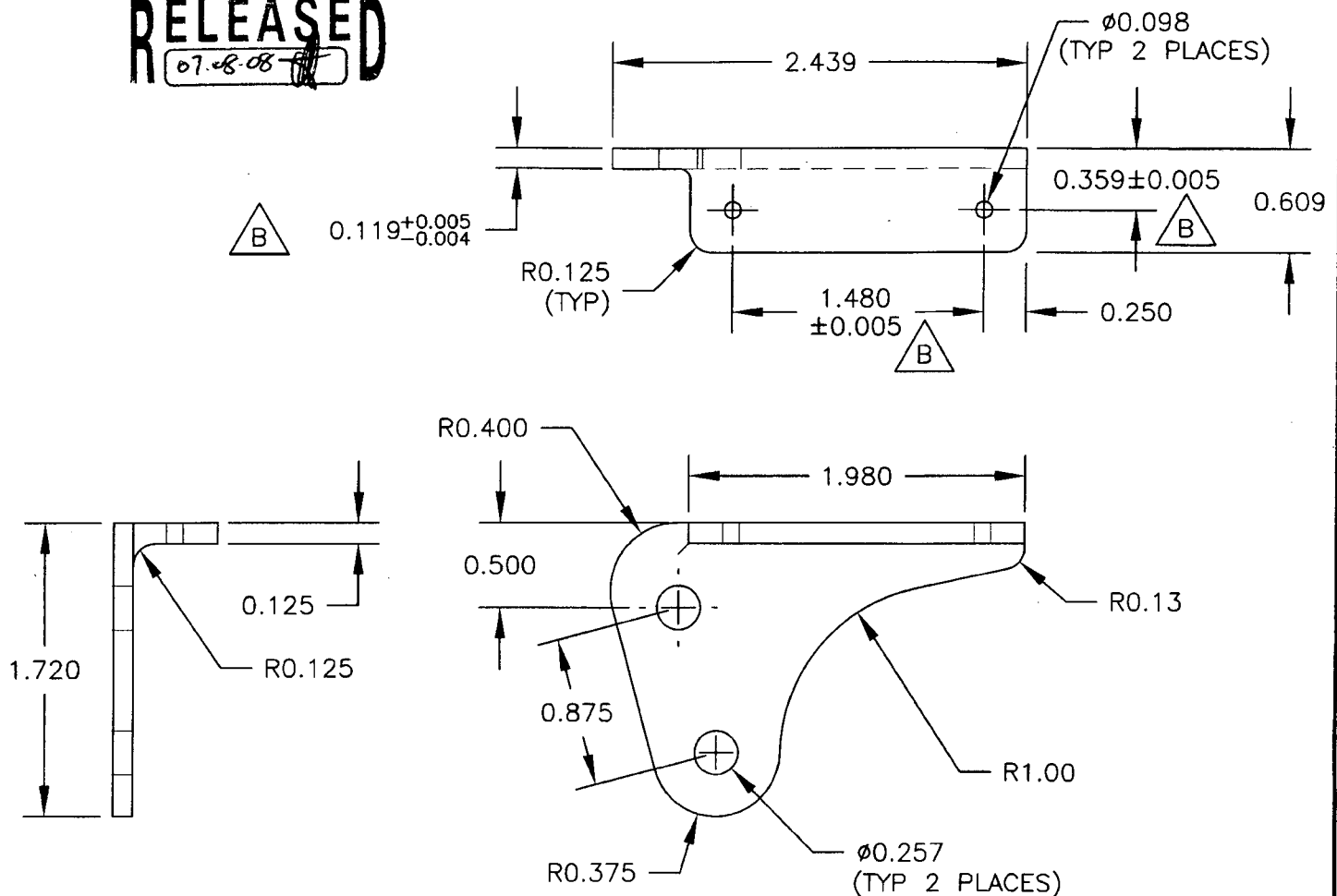
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NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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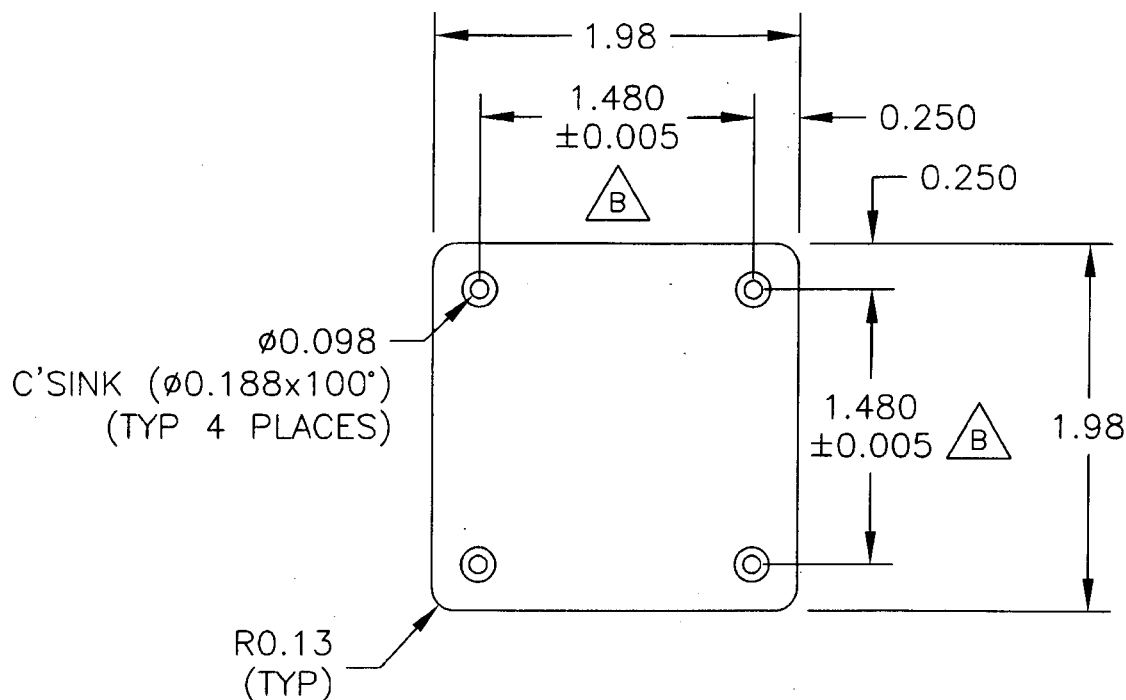
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DART

DESIGN <i>gp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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